

82274

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

5

Cust Item ID:

5

Customer:

Run Start *NR1*

Date:

Stop *NR2*

Date:

SPC (Y/N):

Date:

Draw Nbr	Revision Nbr
D3566	Rev C

0.00

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3566 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82274

82274

Page 2

March-27-12 2:48:27 PM

Item ID: D3566-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 27/03/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/04/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *STEP*

0.00

130

Packaging

Memo

0.00

Packaging

(C) SP 12-04-08

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/5
1204-5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-27-12 2:48:31 PM

Page 1

Work Order ID: 82274

82274

Parent Item: D3566-5

D3566-5

Parent Item Name: Gasket

Start Date: 27/03/2012

Required Date: 10/04/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	702.5020	1.06	5.888889			

MNEO60S 06.3

**

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

702.502

119777

3.752

120948

698.75

120948 B / JM 120403 (5)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82274
Description: Gasket		Part Number:	D3566-5
Inspection Dwg: D3566 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38.50	+/-0.030	38.50	✓		MT	HB-01
43.50	+/-0.030	43.50	✓		MT	HB-01
5.50 Pitch	+/-0.030	5.50	✓		MT	HB-01
2.50	+/-0.030	2.50	✓		Vern	HB-02
2.43	+/-0.030	2.43	✓		Vern	HB-02
3.10	+/-0.030	3.10	✓		Vern	HB-02
2.50	+/-0.030	2.50	✓		Vern	HB-02
0.30	+/-0.030	0.30	✓		Vern	HB-02
0.30	+/-0.030	0.30	✓		Vern	HB-02
0.063	+/-0.010	0.063	✓		Vern	HB-02
6.75	+/-0.030	6.75	✓		Vern	HB-02
10.00	+/-0.030	10.00	✓		Vern	PROD. W-5-02
20.00	+/-0.030	20.00	✓		MT	HB-01
30.00	+/-0.030	30.00	✓		MT	HB-01
Ø0.19	+/-0.030	0.185	✓		MT	HB-02

Measured by: <i>GP/Im</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 12 04 03	Date: 12/04/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.06	Ø0.188 dimension removed	KJ/JLM	
D	08.01.16	Dwg Rev updated	KJ/EC/DD	<i>[Signature]</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

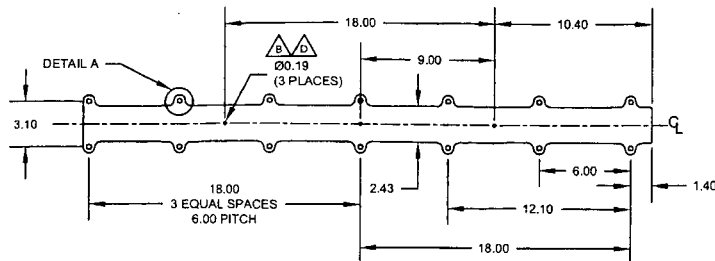
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

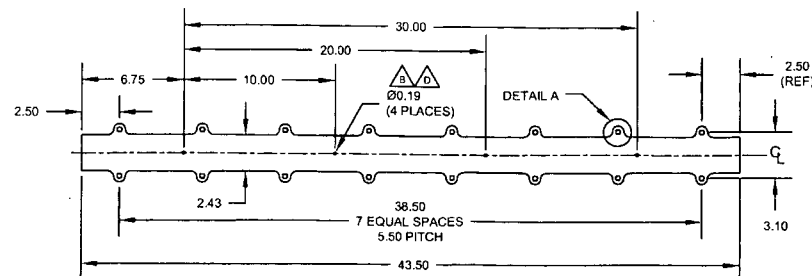
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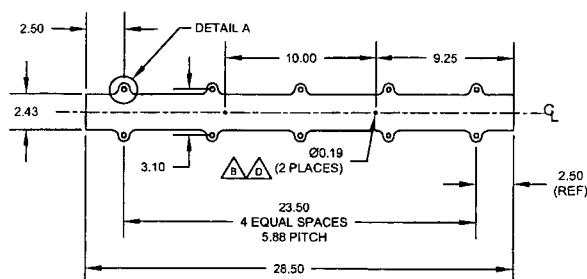
8 7 6 5 4 3 2 1



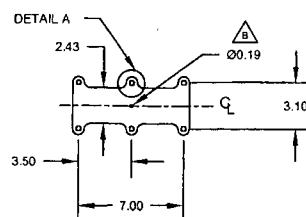
D3566-1 GASKET



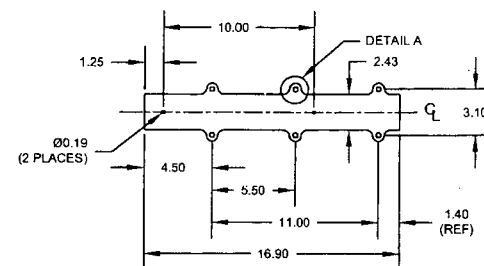
D3566-5 GASKET



D3566-7 GASKET



D3566-13 GASKET

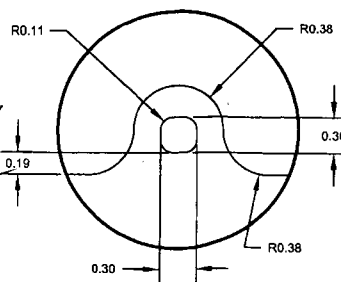


D3566-15 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 02274 MCT
12/03/27

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT CL



**DETAIL A
SCALE 1:1**

WEIGHTS:

D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

RELEASED

07.08.04

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3566
TITLE GASKET
REV. C
SHEET 1 OF 1
SCALE 1:8

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